

# Work Order ID 82876

**\*82876\***

Page 1

April-10-12 2:35:06 PM

Item ID: D4407-1

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Bar

Stop

**\*NS2\***

Start Date: 10/04/2012 Start Qty: 30.00

**\*30\***

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 30.00

**\*30\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/10 Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4407

B

100

0.00

**\*100\***

Cold Saw

Memo

0.00

Hyd Mech

Cut blanks at 66.10"

110

0.00

**\*110\***

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Mill as per folio FB082 & dwg D4407,

FOLIO REV: AA

DWG REV: B

2-Deburr as required

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*82876\***

April-10-12 2:35:06 PM

**\*N900040100\***

Setup Start **\*NS1\***

Stop \*NS2\*

**Start Date:** 10/04/2012    **Start Qty:** 30.00    **\*30\***

**Required Date:** 24/04/2012      **Req'd Qty:** 30.00      **\*30\***

**Reference:**

Approvals: \_\_\_\_\_ Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ **\*NR2\***

120 QC2- Inspect parts off machine FAI/FAIB

**\*120\***

QC

## Memo

## Quality Control

130

QC8- Inspect parts - second check

**\*130\***

QC

## Memo

## Quality Control

140

Identify as per dwg & Stock Location: W/A

**\*140\***

### Packaging

## Memo

## Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 82876****\*82876\***

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April-10-12 2:35:06 PM

Item ID: D4407-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Bar

Stop **\*NS2\***

Start Date: 10/04/2012 Start Qty: 30.00

**\*30\***

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 30.00

**\*30\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

**\*150\***

QC

Memo

0.00

Quality Control

12/4/12

P120414

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

April-10-12 2:35:09 PM

Page 1

Work Order ID: 82876

\*82876\*

Parent Item: D4407-1

\*D4407-1\*

Parent Item Name: Bar

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP revA 11.06.06 new issue EC verified by:DD  
12/02/13 Now on cnc JFS verified by:JLM

IPP revB

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased		No		100	f	542.9540	5.508	173.9368			

\*M304B0 250x0 500\*

\*\*

304 BAR .250 x .500

Location

Loc Qty

Loc Code

MAT006

33.874

120696

33.874

MAT050

509.08

→ 121216

509.08

181 OK 12/04/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

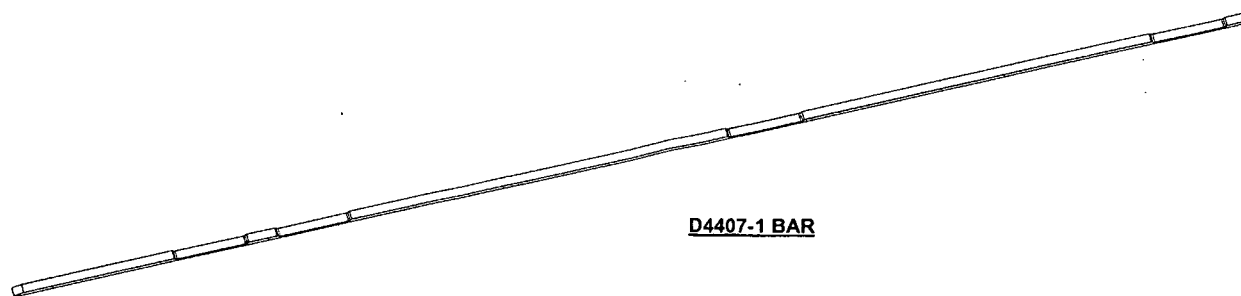
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

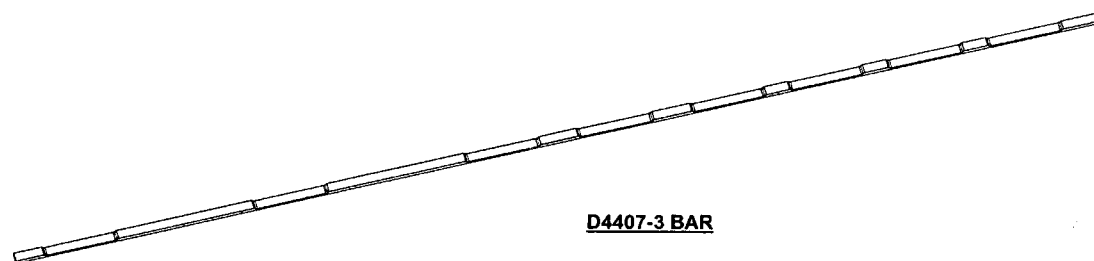
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries





**D4407-1 BAR**



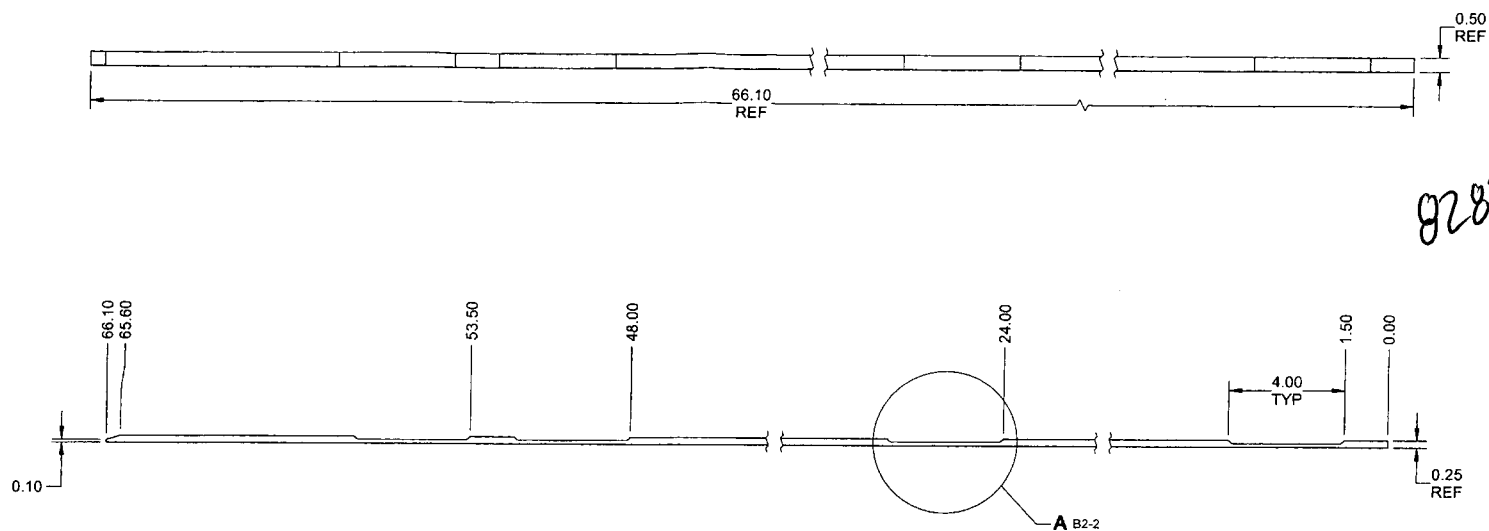
**D4407-3 BAR**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

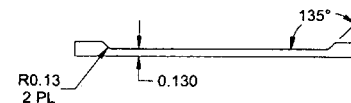
82876 MCT  
12/04/10

RELEASED  
2012-02-23  
MT

B	REMOVE TOOLING HOLES FOR -1/3; RE-DESIGN D4407-3	RF	12.01.30
A	NEW ISSUE	RF	11.08.15
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4407	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BAR	NTS
DATE	12.01.30	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR QUOTED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



# **D4407-1 BAR**



**DETAIL A** C3-2  
TYP. SCALE 2X

RELEASED  
2012-01-30

## **NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL, 0.250 x 0.500 BAR  
PER ASTM A276 OR ASTM 240  
REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: = 2.11 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	<b>D4407</b>	SHEET 2 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	<b>BAR</b>	NTS
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